

Work Order ID 121293

Friday, June 20, 2014 1:36:17 PM

Sup July 4

ASAP

SEE ATTACHED EMAIL

121293

Page 1

Item ID: D4895-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Outboard Beam Assembly

Stop

NS2

Start Date: 6/23/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/04/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

14-6-20

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4895	A U/R

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4895-1_BLANK

006176 1.00 x 12.00

6

mm

14/07/03

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER FOLIO FB194 AND DWG D4895

FOLIO REV: AA

DWG REV: A

DEBURR

6

0

DAS
20
9-89

140704

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Design									
Doc/Data									
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Training									
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121293

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Fwd Outboard Beam Assembly

Start Date: 6/23/14 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 7/04/14 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC8- Inspect parts - second check

0.00

150

0.00

OC

Memo

Quality Control

MH

14/07/07

160 Chemical Conversion Coat per QSI005 4.1

0.00

160

0.00

HandFinish

Memo

Hand Finishing

170 QC7-Inspect Chemical Conversion Coat

0.00

170

0.00

QC

Memo

Quality Control

DAS 34

DQA: _____ Date: _____



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Work Order ID 121293

121293

Page 4

Friday, June 20, 2014 1:36:17 PM

Item ID: D4895-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Outboard Beam Assembly
 Start Date: 6/23/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/04/14 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
171	White Gloss(Ref:4.3.5.1) per QSI005.4.3=Alum	0.00							
171	<i>11/08/09</i>					<i>6</i>	<i>0</i>	<i>14-7-7-</i>	<i>DAS 34 9-89</i>
Powdercoat	<i>START: 1:05</i>	0.00							
Powder Coating	<i>QENT: 3:00</i>								
	<i>FINISH: 2:05</i>								
	Memo MASK HOLES AS PER NOTE 8								
172	QC3- Inspect Part Finish	0.00							
172						<i>6</i>			
QC		0.00							
Quality Control	Memo								
180		0.00							
180						<i>6x</i>			<i>14/07/14</i>
Small Fab		0.00							<i>DAS 36 9-89</i>
Small Fab	Memo								
	INSTALL NUTPLATE AS PER DWG								

DQA: _____ Date: _____



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 121293

Friday, June 20, 2014 1:36:17 PM

121293

Page 5

Item.ID: D4895-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Outboard Beam Assembly
Start Date: 6/23/14 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/04/14 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 8-23 0.00 M/H/14				6			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 PPO 121274 0.00				14/7/14			
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLG 14-07-14			

14-07-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
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FAULT CATEGORY

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Picklist Print

Friday, June 20, 2014 1:36:20 PM

Work Order ID: 121293

121293

Parent Item: D4895-041

D4895-041

Parent Item Name: Fwd Outboard Beam Assembly

Start Date: 6/23/14

Required Date: 7/04/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased	No				f	16.6400		20			

M6061T6B1 000X12 000

6061-T6 Bar 1.00 x 12.00

**

mm 17/07/03

Location	Loc Qty	Loc Code
MAT005 m129639	16.64	
116406	8	
123649	2	
M126075	5.64	
M126351	1	

MS21059L4

Purchased

No

Each

50.0000

12

MS21059L 4

Nutplate

**

14/07/08 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	10	
125535	10	
ST316	40	
m128401	15	
m129022	25	

MS20426AD3-56

Purchased

No

Each

6,732.000

24

MS20426AD3-5

Rivet

**

M12976A 82
14/07/08 DAS 36 9-89

Location	Loc Qty	Loc Code
GA	4818	
4533	4818	
ST334	1914	
4444	1914	

M120123

24K

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

DART AEROSPACE LTD		Work Order:	121293
Description: FWD outboard Beam ASS.		Part Number:	D4895-1
Inspection Dwg: D4895 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	+/- .010	.503	—		Vern	M/DL
.25	+/- .030	.248	✓		SL11	Depth gauge
5.50	+/- .030	5.500	✓		SLO8	Vern
R.25	+/- .030	.250	✓		Rad gauge	
32.55	+/- .030	32.550	✓		SLO1	Tapel
.200	+/- .010	.202	✓		"	
12.000	+/- .010	12.002	✓		12" Vern	
1.54	+/- .030	1.540	✓		SLO8	
8.32	+/- .030	8.315	✓		Height gauge	
Ø.257	+ .005 / - .001	.257	✓		gauge Pin	
.80	+/- .030	.794	✓		SLO8	
3.50	+/- .030	3.503	✓		"	
.15	+/- .030	.150	✓		"	
.250	+/- .010	.250	✓		"	
5.75	+/- .030	5.752	✓		"	
1.34	+/- .030	1.341	✓		Height gauge	
1.00	+/- .030	1.004	✓		SLO8	
R.13	+/- .030	.125	✓		Rad gauge	
.150	+/- .010	.154	✓		Deep throat Mic	

DAS

20

9-89

Measured by:	Audited by:	Preliminary Approval:
Date: 14-07-03	M4 Date: 14/07/07	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order: 121 293
Description: FWD OUTBOARD Beam ASS.	Part Number: 04895-1
Inspection Dwg: 04895 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.00	+/- .030	1.000	✓		gauge Pin	
1.15	+/- .030	1.150	✓		SLO8	
3.00	+/- .030	3.001	✓		"	
Ø .377	+ .006 / - .001	.377	✓		"	
3.50	+/- .030	3.501	✓		"	
3.600	+/- .010	3.600	✓		"	
.80	+/- .030	.799	✓		"	
.60	+/- .030	.599	✓		"	
2.300	+/- .010	2.300	✓		"	
.60	± .030	.600	✓		Vern	OK
1.55	± .030	1.555	✓		"	
12.000	± .005	12.000	✓		Vern	OK
Ø .260	± .005 / - .001	Ø .260	✓		Vern	OK
.500	± .005	.500	✓		"	
Ø .098	± .004 / - .001	Ø .098	✓		"	
Ø .179 X 100°	± .010 X ± 1/2°	Ø .179 X 100°	✓		"	

DAS

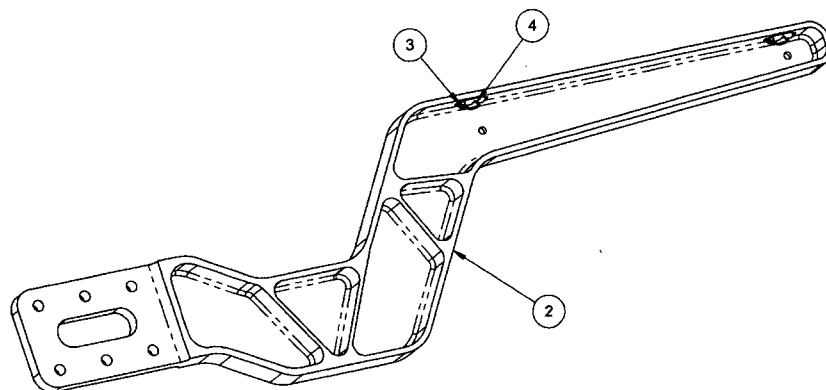
20

9-89

Measured by:	Audited by: MH	Preliminary Approval:
Date: 14-07-03	Date: 14/07/07	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4895-041 FWD OUTBOARD BEAM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.31 lbs

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4895-041	FWD OUTBOARD BEAM ASSY
2	1	D4895-1	FWD OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059L4	ANCHOR NUT

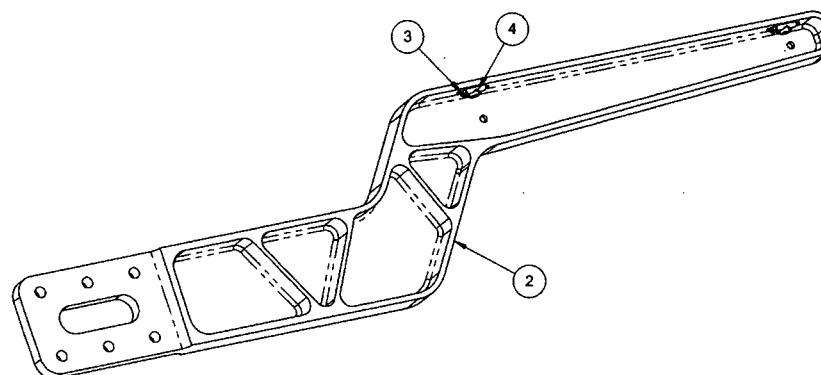
UNDER REVIEW

14.06.05

RELEASED
2013-06-12

A		NEW ISSUE		RF	13.05.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF				
CHECKED	<i>[Signature]</i>	DRAWING NO.		SHEET 1 OF 5	
MFG. APPR.	<i>[Signature]</i>	D4895			
APPROVED	<i>[Signature]</i>	TITLE		SCALE	
DE APPR.	<i>[Signature]</i>	OUTBOARD BEAM		NTS	
DATE		13.05.24			
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4895-043	AFT OUTBOARD BEAM ASSY
2	1	D4895-3	AFT OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059L4	ANCHOR NUT



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121293MP
14-6-20

D4895-043 AFT OUTBOARD BEAM ASSY

UNDER REVIEW

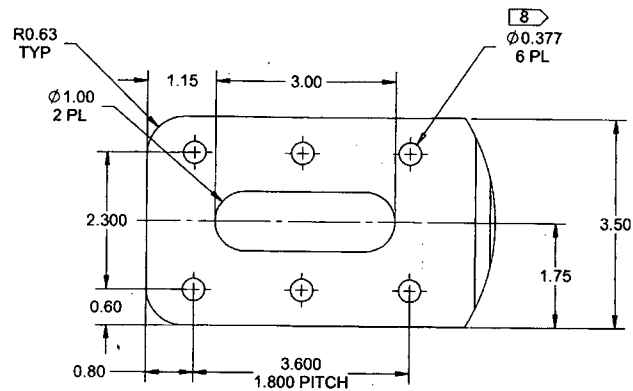
14.06.05

RELEASED
14.06.05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.25 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4895	SHEET 2 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD BEAM	NTS
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DETAIL B C8-3
C8-4

RELEASED
2013-06-12
14.06.05

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4895	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD BEAM	NTS
DATE	13.05.24	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Mario Poulin

From: Harvey Siemens
Sent: Friday, June 20, 2014 3:03 PM
To: Linda Lacelle
Cc: Mario Poulin
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Linda,

OK to manufacture D117-837 baskets that are under review believing that the customer doesn't want the quick release version.

Regards,

Harvey

From: Linda Lacelle
Sent: June-20-14 12:51 PM
To: Harvey Siemens
Cc: Mario Poulin
Subject: FW: NEW SO117104 FOR HELI NIUGINI - ALISON

Harvey,

Just received an order for 2 x 117 baskets, current style, D4894-1/-3 & D4895-041/043 are in the U/R folder, can you pls send this email back saying ok to mfg, so I can proceed with production?

Thx

L

From: Alison Markus
Sent: June-20-14 9:47 AM
To: Linda Lacelle; Nancy MacLeod; Melanie Fauteux; Ruth Molnar; Brigitte Golden; Mario Poulin
Cc: Shirley Hay; Linda Pilon; Chantal Chartrand; Diana Hagen; Carrie Pearson; Jean Kerr
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Old version

ALISON MARKUS
Sales Representative



From: Linda Lacelle
Sent: June 20, 2014 9:46 AM
To: Nancy MacLeod; Melanie Fauteux; Ruth Molnar; Brigitte Golden; Mario Poulin
Cc: Shirley Hay; Linda Pilon; Chantal Chartrand; Diana Hagen; Carrie Pearson; Jean Kerr; Alison Markus
Subject: RE: NEW SO117104 FOR HELI NIUGINI - ALISON

Is this at the new CHG or the current change pls??